

Date: Tuesday, 23/09/2008 10:23:42 AM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	SADDLE KIT FOR D206-642-511	
Job Number :	42242			
Estimate Number :	12893			
P.O. Number :		Part Number :	K642 511	
This Issue :	23/09/2008	S.O. No. :		
Prsht Rev. :	NC	Drawing Number :	N/A	
First Issue :	//	Project Number :	N/A	
Previous Run :	40258	Drawing Revision :	N/A	
		Material :		
		Due Date :	10/10/2008	Qty: 2 Um: Each
Written By :				
Checked & Approved By :	<u>JUO 08.9.23</u>			
Comment :	Est Rev:A 07.06.05 new issue EC Est Rev.B 08.02.05, Per ECN1080P LL			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	DC	DOCUMENT CONTROL
-----	----	------------------



JUO 08.11.21



Comment: DOCUMENT CONTROL

Create White labels per PPP K642-511 CHG003

2.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0	D206648013	GHW Modification
-----	------------	------------------



Comment: Qty.: 1 Each(s)/Unit Total: 2 Each(s)

GHW Kit

Batch:

46443

JS 08/11/07

4.0	D2652	Bushing
-----	-------	---------



Comment: Qty.: 16 Each(s)/Unit Total: 32 Each(s)

Pick:

Qty Part Number

Description

Batch

16 D2652

Bushing

B44637x21 B42362x10

JS 08/11/07

5.0	D2712	Set Screw
-----	-------	-----------



Comment: Qty.: 10 Each(s)/Unit Total: 20 Each(s)

Pick:

Qty Part Number

Description

Batch

10 D2712

Set Screw

41126

JS 08/11/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 23/09/2008 10:23:42 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE KIT FOR D206-642-511

Job Number: 42242

Part Number: K642 511

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 D29321 Saddle LH Out, 206



Comment: Qty.: 1 Each(s)/Unit Total : 2 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2932-1

Saddle

41128 1X

SS 08/11/07

7.0 D29331 Saddle LH In, 206



Comment: Qty.: 1 Each(s)/Unit Total : 2 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2933-1

Saddle

40281

SS 08/11/07

8.0 D2934 Saddle Spacer



Comment: Qty.: 2 Each(s)/Unit Total : 4 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2934

Saddle Spacer

41130 x3

SS 08/11/07

9.0 D2935 Saddle Spacer



Comment: Qty.: 2 Each(s)/Unit Total : 4 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2935

Saddle Spacer

42262

SS 08/11/07

10.0 D29381 Saddle LH Out, 206



Comment: Qty.: 1 Each(s)/Unit Total : 2 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2938-1

Saddle

37424

SS 08/11/07

11.0 D29391 Saddle LH In, 206



Comment: Qty.: 1 Each(s)/Unit Total : 2 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2939-1

Saddle

40283

SS 08/11/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 23/09/2008 10:23:43 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE KIT FOR D206-642-511

Job Number: 42242

Part Number: K642 511

Job Number:



Seq. #: Machine Or Operation: Description :

12.0 D33963 Spacer

X



Comment: Qty.: 2 Each(s)/Unit Total : 4 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D3396-3

Spacer

36336

SS 08/11/07 (2)

13.0 D3407043 Tow Ring

X



Comment: Qty.: 1 Each(s)/Unit Total : 2 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3407-043

Tow Ring

B42211

SS 08/11/07 (2)

14.0 D34561 Washer

X



Comment: Qty.: 1 Each(s)/Unit Total : 2 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3456-1

Washer

40285

SS 08/11/07 (2)

15.0 D34571 Washer

X



Comment: Qty.: 2 Each(s)/Unit Total : 4 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D3457-1

Washer

B42719

SS 08/11/07 (2)

16.0 AN3C35A BOLT

X



Comment: Qty.: 3 Each(s)/Unit Total : 6 Each(s)

Pick:

Qty Part Number

Description

Batch

3 AN3C35A

Bolt

M109323

SS 08/11/07 (2)

17.0 AN3C36A BOLT

X



Comment: Qty.: 9 Each(s)/Unit Total : 18 Each(s)

Pick:

Qty Part Number

Description

Batch

9 AN3C36A

Bolt

M109771

SS 08/11/07 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 23/09/2008 10:23:43 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE KIT FOR D206-642-511

Job Number: 42242

Part Number: K642 511

Job Number:



Seq. #: Machine Or Operation: Description :

18.0 AN3C41A BOLT



Comment: Qty.: 8 Each(s)/Unit Total : 16 Each(s)

Pick:

Qty Part Number

Description

Batch

8 AN3C41A

Bolt

M108084

SS 08/11/07 (x2)

19.0 AN4C6A Bolt



Comment: Qty.: 12 Each(s)/Unit Total : 24 Each(s)

Pick:

Qty Part Number

Description

Batch

12 AN4C6A

Bolt

M107242

SS 08/11/07 (x2)

20.0 AN5C11A



Comment: Qty.: 8 Each(s)/Unit Total : 16 Each(s)

Pick:

Qty Part Number

Description

Batch

8 AN5C11A

Bolt

M108428

SS 08/11/07 (x2)

21.0 AN5C12A



Comment: Qty.: 4 Each(s)/Unit Total : 8 Each(s)

Pick:

Qty Part Number

Description

Batch

4 AN5C12A

Bolt

M107328

SS 08/11/07 (x2)

22.0 AN5C13A



Comment: Qty.: 4 Each(s)/Unit Total : 8 Each(s)

Pick:

Qty Part Number

Description

Batch

4 AN5C13A

Bolt

M107615

SS 08/11/07 (x2)

23.0 AN5C15A



Comment: Qty.: 1 Each(s)/Unit Total : 2 Each(s)

Pick:

Qty Part Number

Description

Batch

1 AN5C15A

Bolt

M105125

SS 08/11/07 (x2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 23/09/2008 10:23:43 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE KIT FOR D206-642-511

Job Number: 42242

Part Number: K642 511

Job Number:



Seq. #: Machine Or Operation:

Description :

24.0 AN5C32A



Comment: Qty.: 2 Each(s)/Unit Total : 4 Each(s)

Pick:

Qty Part Number

Description

Batch

2 AN5C32A

Bolt

M107463

SS

08/11/07 (x2)

25.0 AN5C34A



Comment: Qty.: 2 Each(s)/Unit Total : 4 Each(s)

Pick:

Qty Part Number

Description

Batch

2 AN5C34A

Bolt

M107289

SS

08/11/07 (x2)

26.0 AN5C35A



Comment: Qty.: 1 Each(s)/Unit Total : 2 Each(s)

Pick:

Qty Part Number

Description

Batch

1 AN5C35A

Bolt

M107551

SS

08/11/07 (x2)

27.0 AN960C10L

washer



Comment: Qty.: 24 Each(s)/Unit Total : 48 Each(s)

Pick:

Qty Part Number

Description

Batch

24 AN960C10L

Washer

M109752

SS

08/11/07 (x2)

28.0 AN960C416L

WASHER



Comment: Qty.: 24 Each(s)/Unit Total : 48 Each(s)

Pick:

Qty Part Number

Description

Batch

24 AN960C416L

Washer

M109220

SS

08/11/07 (x2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 23/09/2008 10:23:43 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE KIT FOR D206-642-511

Job Number: 42242

Part Number: K642 511

Job Number:



Seq. #: Machine Or Operation: Description :

29.0 AN960C516L WASHER



Comment: Qty.: 8 Each(s)/Unit Total: 16 Each(s)

Pick:

Qty Part Number Description Batch
8 AN960C516L Washer M103344

30.0 MS210433 Nut



Comment: Qty.: 20 Each(s)/Unit Total: 40 Each(s)

Pick:

Qty Part Number Description Batch
20 MS21043-3 Nut M108880

31.0 MS210434 Nut



Comment: Qty.: 13 Each(s)/Unit Total: 26 Each(s)

Pick:

Qty Part Number Description Batch
13 MS21043-4 Nut M108672

32.0 MS210435 Nut



Comment: Qty.: 4 Each(s)/Unit Total: 8 Each(s)

Pick:

Qty Part Number Description Batch
4 MS21043-5Nut M109535

33.0 D36721 Phenolic Washer



Comment: Qty.: 24 Each(s)/Unit Total: 48 Each(s)

PHENOLIC WASHER

34.0 D36723 Phenolic Washer



Comment: Qty.: 24 Each(s)/Unit Total: 48 Each(s)

PHENOLIC WASHER

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 23/09/2008 10:23:43 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE KIT FOR D206-642-511

Job Number: 42242

Part Number: K642 511

Job Number:



Seq. #:

Machine Or Operation:

Description :

35.0

D36725

Phenolic Washer



1735521



SD

Comment: Qty.: 16 Each(s)/Unit Total : 32 Each(s)

PHENOLIC WASHER

36.0

D36727

Phenolic Washer



1735522



SD

Comment: Qty.: 8 Each(s)/Unit Total : 16 Each(s)

PHENOLIC WASHER

37.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

08/11/20

38.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP K642-511 CHG003

Location: Rev D

08/11/20

39.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/20

Job Completion



MF 08-11-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries